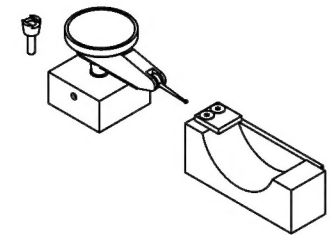
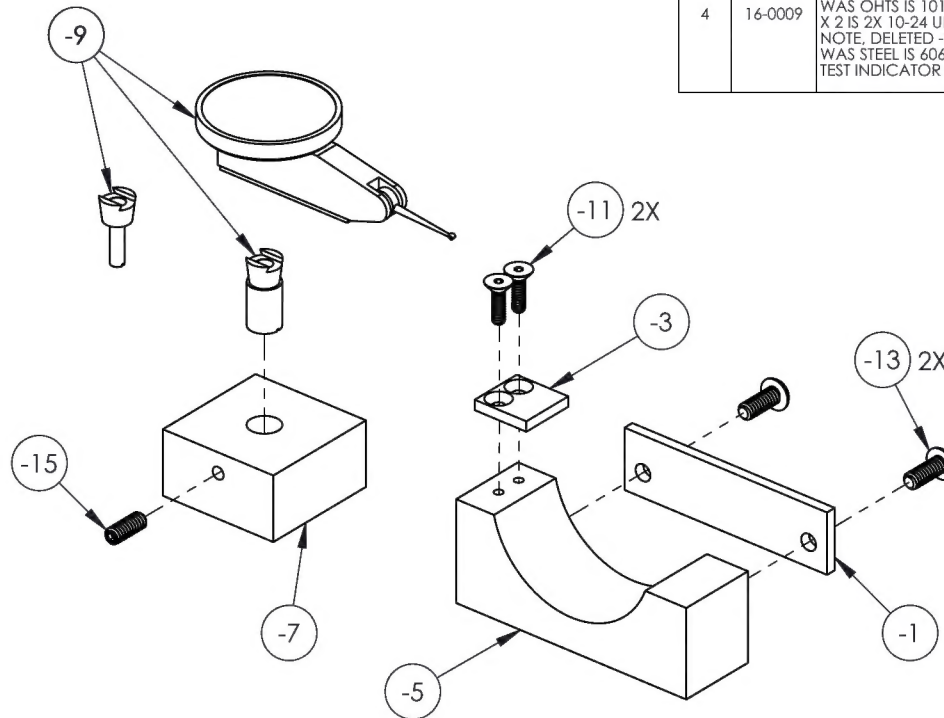


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D 6-32 HOLE LOCATION & LENGTH. -7 CH'D HEIGHT.	8/14/2000		
2		-5 CENTER OF R1.076 MOVED TO PART MIDPOINT.	12/17/2003		
3		-5 CH'D HOLE LOCATION FROM .46 TO .44.	3/28/2006		
3A		CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS TO NUMERICAL, MOVE -5 & -7 TO NEW SHEETS FOR CLARITY.	7/16/2009	RJC	
3B		ADDED NEEDLE NOTE, ACCEPTABLE TO CUT INTO SHAFT IF NEEDED.	10/22/2012	RJC	RW
4	16-0009	DELETED NOTE 1 SHT 1, -9, -11, -13, & -15. ADDED B/O INFO. -1 CH'D DIM WAS 2X Ø.190 THRU IS 2X Ø.201 THRU ALL, CH'D MATERIAL WAS CRS IS 1018/1020 CR. -3 ADDED MISSING DIM .18, CH'D DIM WAS 2X Ø.138 THRU 82° FOR 6-32 FLAT HEAD IS 2X Ø.15 THRU ALL 82°. CH'D MATERIAL WAS OHTS IS 1018/1020 CR. DELETED SURFACE FINISH CALLOUT. -5 CH'D DIM WAS 10-24 NC .50 DEEP X 2 IS 2X 10-24 UNC -2B .50, WAS 6-32 NC .50 DEEP X2 IS 2X 6-32 UNC -2B .50, ADDED ENGRAVE NOTE, DELETED -3 FROM THIS PART. CH'D MATERIAL WAS STEEL IS 1018/1020 CR. -7 CH'D MATERIAL WAS STEEL IS 6061, CH'D FINISH WAS BLACK OXIDE IS BLACK ANODIZE. -9 CH'D DESCRIPTION WAS TEST INDICATOR IS DIAL INDICATOR, ADDED NOTE 1 & (90° DIM).	1/29/2016	RJC	JAG

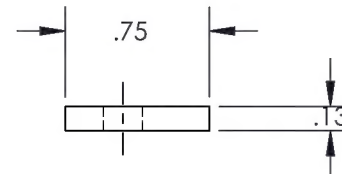
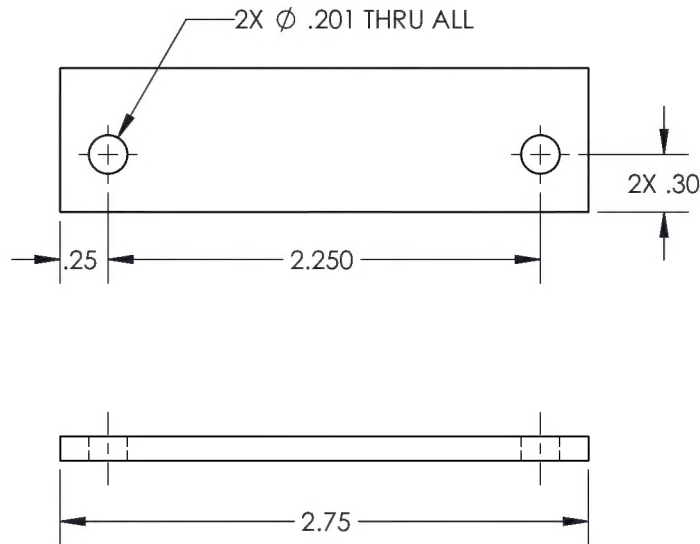
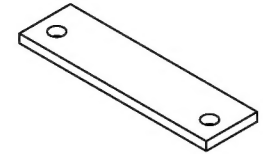


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SIDE PLATE	1018/1020 CR		2
			-3	1	BAR	1018/1020 CR		3
			-5	1	BASE	1018/1020 CR		4
			-7	1	INDICATOR BLOCK	6061		5
			-9	1	DIAL INDICATOR		PAC-WEST TOOL #T1030 MODIFIED	6
		B/O	-11	2	FLAT HEAD SOCKET CAP SCREW	S.S	6-32 X 1/2 (MCMaster-CARR #93791A457)	1
		B/O	-13	2	BUTTON HEAD SOCKET HEAD CAP SCREW	STEEL	#10-24 X 1/2 (MCMaster-CARR #91255A242)	1
		B/O	-15	1	SET SCREW	STEEL	#10-24 X 1/2 (MCMaster-CARR #91375A242)	1
		B/O	-17	1	SMALL PISTOL CASE	PLASTIC	RSR GROUP #10137	N/S

DART AEROSPACE	
TITLE TEST FIXTURE SPRAG CLUTCH	
DWG NO. RBT18612	REV 4
MAT'L HEAT TREAT FINISH SPEC	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL MD	
SCALE 2:1	DATE 1/29/2016
SHEET 1 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	16-0009	-1 CH'D DIM WAS 2X Ø.190 THRU IS 2X Ø.201 THRU ALL, CH'D MATERIAL WAS CRS IS 1018/1020 CR.	1/29/2016	RJC	JAG

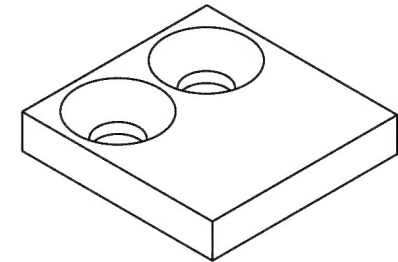
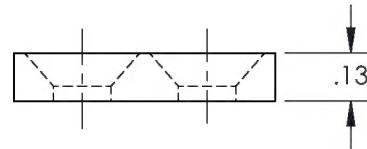
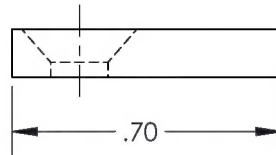
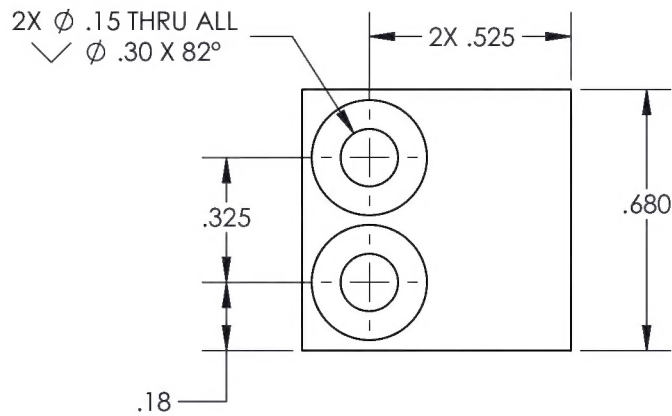


(-1)
SIDE PLATE

DART AEROSPACE	
TITLE TEST FIXTURE SPRAG CLUTCH	
DWG NO. RBT18612-1	REV 4
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 1/29/2016
	USED ON MODEL MD
	SHEET 2 OF 6

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	16-0009	-3 ADDED MISSING DIM .18, CH'D DIM WAS 2X Ø.138 THRU ∇ 82° FOR 6-32 FLAT HEAD IS 2X Ø.15 THRU ALL ∇ Ø.30 X 82°, CH'D MATERIAL WAS OHTS IS 1018/1020 CR, DELETED SURFACE FINISH CALLOUT.	1/29/2016	RJC	JAG

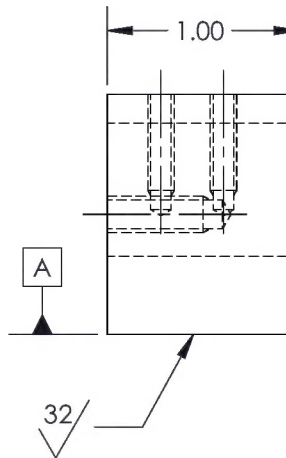
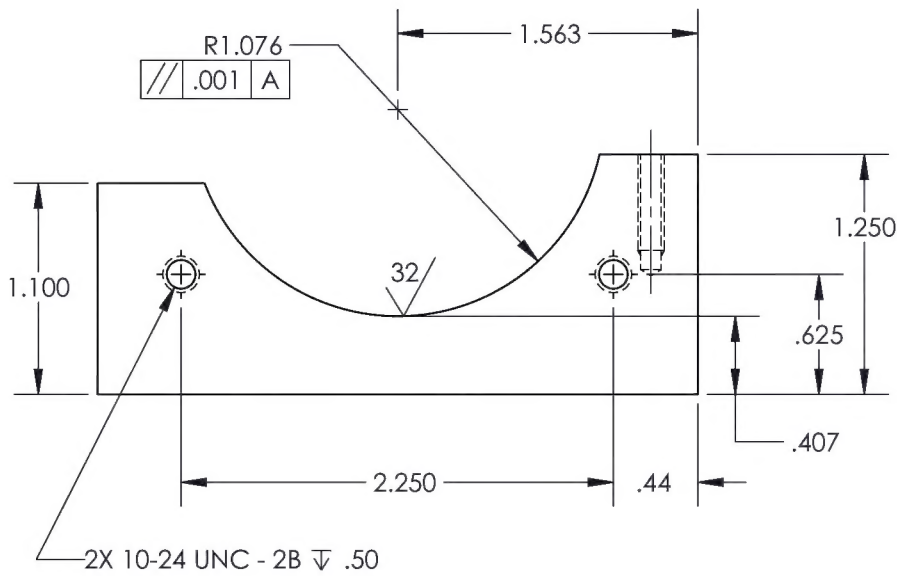
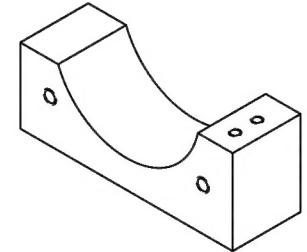
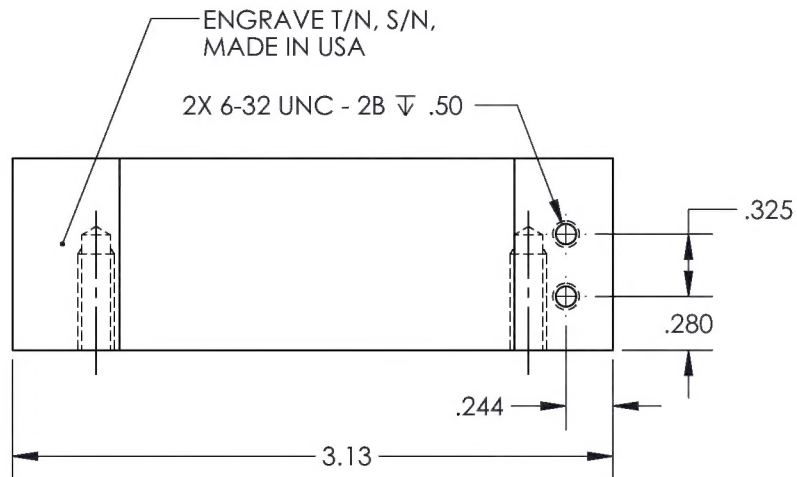


(-3)
 BAR

DART AEROSPACE	
TITLE TEST FIXTURE SPRAG CLUTCH	
DWG NO. RBT18612-3	REV 4
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	MD
SCALE 2:1	DATE 1/29/2016
	SHEET 3 OF 6

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D 6-32 HOLE LOCATION & LENGTH.	8/14/2000		
2		-5 CENTER OF R1.076 MOVED TO PART MIDPOINT .	12/17/2003		
3		-5 CH'D HOLE LOCATION FROM .46 TO .44.	3/28/2006		
4	16-0009	-5 CH'D DIM WAS 10-24 NC .50 DEEP X 2 IS 2X 10-24 UNC -2B ∇ .50, WAS 6-32 NC .50 DEEP X2 IS 2X 6-32 UNC -2B ∇ .50, ADDED ENGRAVE NOTE, DELETED -3 FROM THIS PART, CH'D MATERIAL WAS STEEL IS 1018/1020 CR.	1/29/2016	RJC	JAG

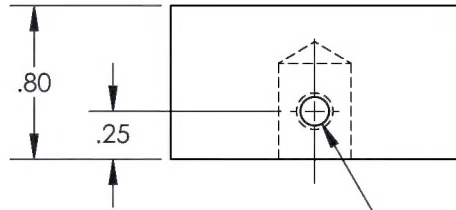
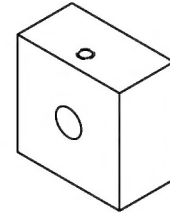


(5)
BASE

DART AEROSPACE	
TITLE TEST FIXTURE SPRAG CLUTCH	
DWG NO. RBT18612-5	REV 4
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm 5°
	.X \pm .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	MD
SCALE 1:1	DATE 1/29/2016
	SHEET 4 OF 6

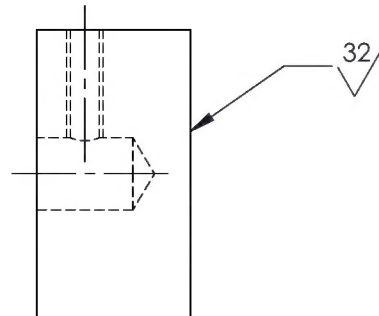
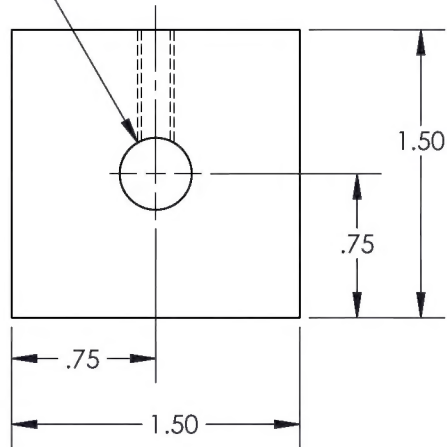
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 CH'D HEIGHT.	8/14/2000		
4	16-0009	-7 CH'D MATERIAL WAS STEEL IS 6061, CH'D FINISH WAS BLACK OXIDE IS BLACK ANODIZE.	1/29/2016	RJC	JAG



10-24 UNC - 2B ∇ .60

$\phi .375^{+.001}_{-.000}$ ∇ .50




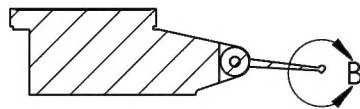
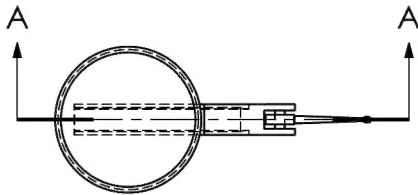
(-7)

INDICATOR BLOCK

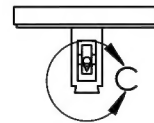
DART AEROSPACE	
TITLE TEST FIXTURE SPRAG CLUTCH	
DWG NO. RBT18612-7	REV 4
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK ANODIZE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC MIL-A-8625, TYPE II, CLASS II	.XX \pm .01 ANGLES \pm .5°
DRAWN BY: CLOUGH	.X \pm .1 SURFACES = 125°
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 1/29/2016	USED ON MODEL
SHEET 5 OF 6	MD

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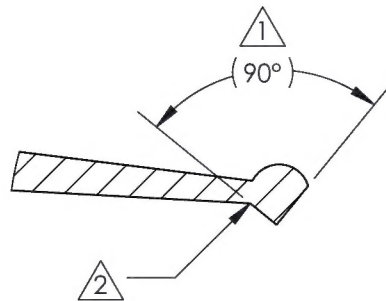
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	16-0009	-9 CH'D DESCRIPTION WAS TEST INDICATOR IS DIAL INDICATOR, ADDED NOTE  & (90° DIM).	1/29/2016	RJC	JAG



SECTION A-A



DETAIL C
SCALE 2 : 1



DETAIL B
SCALE 4 : 1



NOTE:

- ¹ MUST MAKE A SHARP POINT AND ANGLED DOWN.
- ² ACCEPTABLE TO CUT INTO SHAFT IF NEEDED, BE CAREFUL.

DART AEROSPACE	
TITLE TEST FIXTURE SPRAG CLUTCH	
DWG NO. RBT18612-9	REV 4
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH AS PLATED	.XX ± .01 ANGLES ± .5°
SPEC AS PLATED	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: GILBERT	USED ON MODEL
APPROVED: GILBERT	MD
SCALE 1:2	DATE 1/29/2016
SHEET 6 OF 6	